

Work Order ID 62350

September 28, 2010 10:09:55 AM



PRELIMINARY ISSUE

See last

Page 1

Item ID: D4203-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Base

Stop



Start Date: 29/09/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 04/10/2010 Req'd Qty: 1.00



Customer:

Reference:

See 10.09.28



Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4203

PAT

good to Rev A

0.00

100



Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK TO 4.370" LONG

0.00

SL 10/09/29

①

110

0.00



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA 972

FOLIO REV: *AA*

DWG REV: *PAT*

0.00

SL 10/09/29

②

DEBURR

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Page 2

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Start Date: 29/09/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 04/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/09/29



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Jm 10-09-30

①

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

JH 10/10/01

JH

JH

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Page 3

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Required Date: 04/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

BL 10-10-11

M102391 START 2:00

Memo OVERT. 320"

0.00

FINISH 2:30

① ②

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

=) W 10/10/01

Memo

0.00

1 0

170



Packaging

Packaging

Identify as per dwg & Stock Location:

GA

0.00

Memo

0.00

① 5/10/05 ②

Work Order ID 62350

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Page 4

Item ID: D4203-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Base

Start Date: 29/09/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 04/10/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/18 *[Signature]*
U 10005

POSITIVE RECALL

EFFECTIVE 100930 AUTH *[Signature]*
BASED *[Signature]* DATE 10-10-18

Picklist Print

September 28, 2010 10:09:54 AM

Page 1

Work Order ID: 62350



Parent Item: D4203-1



Parent Item Name: Base

Start Date: 29/09/2010

Required Date: 04/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			100	f	113.8002	0.365	0.384211			



6061-T6 Bar 1.50 x 2.50



SL 10/09/29

Location

Loc Qty

Loc Code

MAT10

113.8002105

103069

12

107387

61

16716

4.8002105

16742

36

39

DART AEROSPACE LTD		Work Order: 62530
Description: base		Part Number: D4203-1
Inspection Dwg: D4203 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.50	+ .030	1.499	✓		VERN JL-3	
.760	+ .010	.761	✓		"	
.450	+ .010	.450	✓		"	
2.125	+ .010	DIA 2.125	✓		"	is .770 per Rev. A
1.081	+ .010	1.083	✓		H-G	
1.188	+ .010	1.188	✓		R-G	
.202	+ .010	.202	✓		SH-03	not on Rev. A
3.600	+ .010	3.600	✓		VERN JL-3	
2.161	+ .010	2.160	✓		"	
.188	+ .010	.188	✓		"	
.720	+ .010	.720	✓		"	
1.358	+ .010	1.358	✓		"	
1.188	+ .010	1.187	✓		"	
1.375	+ .010	1.374	✓		"	
.188	+ .010	.190	✓		"	
φ .203	+ .005 - .001	.205	✓		"	
.456 deep	+ .010	.450	✓		"	
4.25	+ .030	4.250	✓		"	
2.763	+ .010	2.763	✓		"	
1.798	+ .010	1.798	✓		"	
.450	+ .010	.450	✓		"	
1.920	+ .010	1.919	✓		"	
2.35	+ .030	2.353	✓		"	

Measured by: SL
Date: 10/09/29

Audited by: [Signature]
Date: 10-09-30

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

D

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D4203-041	TAIL ROTOR DISABLING KIT
1	X	D4203-051	PEDAL LOCK
	1	D4203-1	BASE
	1	D4203-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW
	1	D3370-5b	

C

C

B

B

A

A

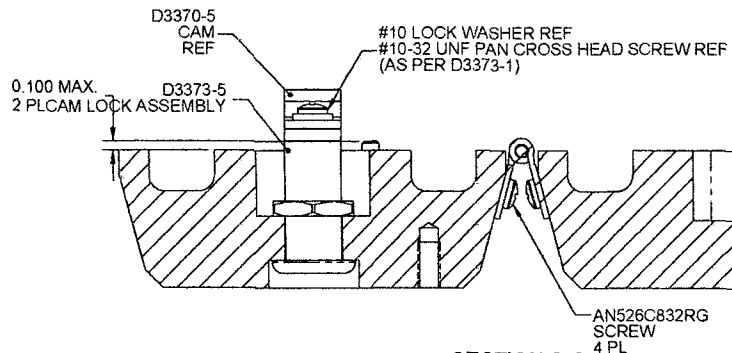
25829 o/m

PRELIMINARY ISSUE
10.09.24
MP

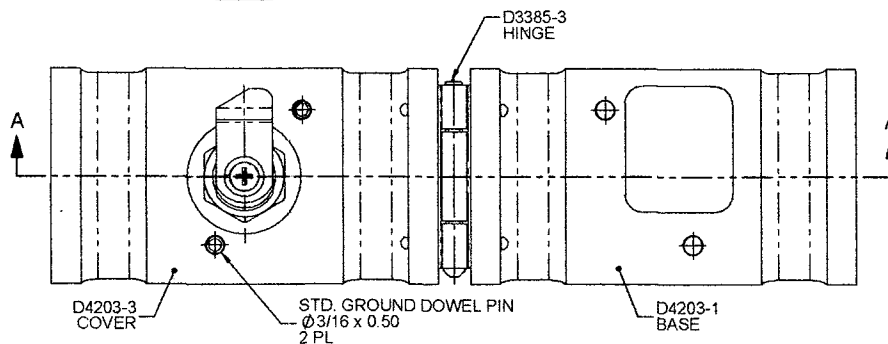
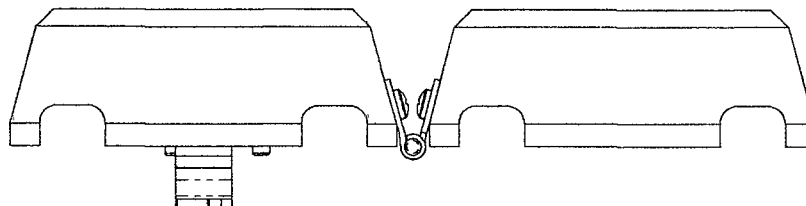
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REV.	DESCRIPTION	BY	DATE
DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4203	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	10.09.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

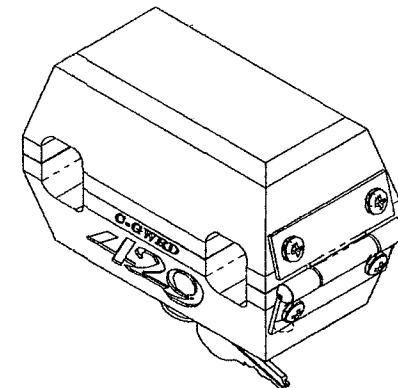


SECTION A-A



D4203-051 PEDAL LOCK ASSEMBLY

QSS29 0/m



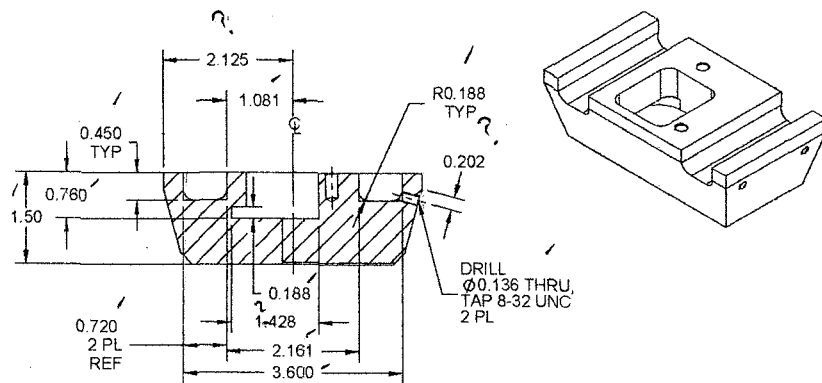
PRELIMINARY ISSUE
10.09.24
MP

NOTES:

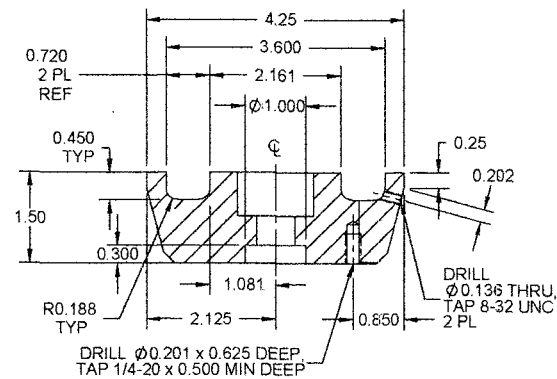
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4203	SHEET 2 OF 3
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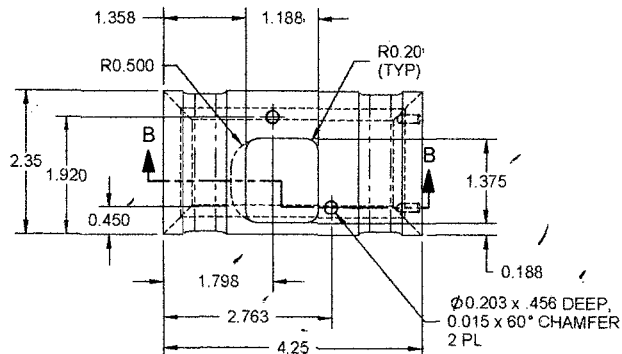
8 7 6 5 4 3 2 1



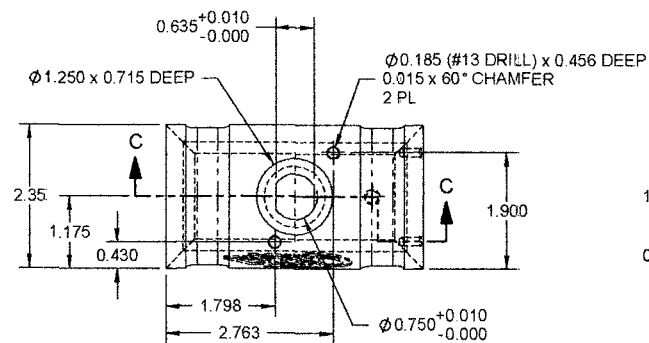
SECTION B-B



SECTION C-C



D42031 BASE



D4203-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) ENGRAVE LOGO AND AIRCRAFT ID PER D4203-3.SLDPRT

PRELIMINARY ISSUE
10.09.24
MP

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MFG. APPR.		D4203	SHEET 3 OF 3
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8 7 6 5 4 3 2 1

D

D

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X		D4203-041	TAIL ROTOR DISABLING KIT
1	X	D4203-051	PEDAL LOCK
	1	D4203-1	BASE
	1	D4203-3	COVER
	1	D3373-5	CAM LOCK ASSY
	1	D3385-3	HINGE
	2	Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
	4	AN526C832R6	SCREW

C

C

B

B

A

A

W/O 62356

RELEASED
R 2010-10-15
MP

A	NEW ISSUE	MP	10.10.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4203	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PEDAL LOCK	NTS
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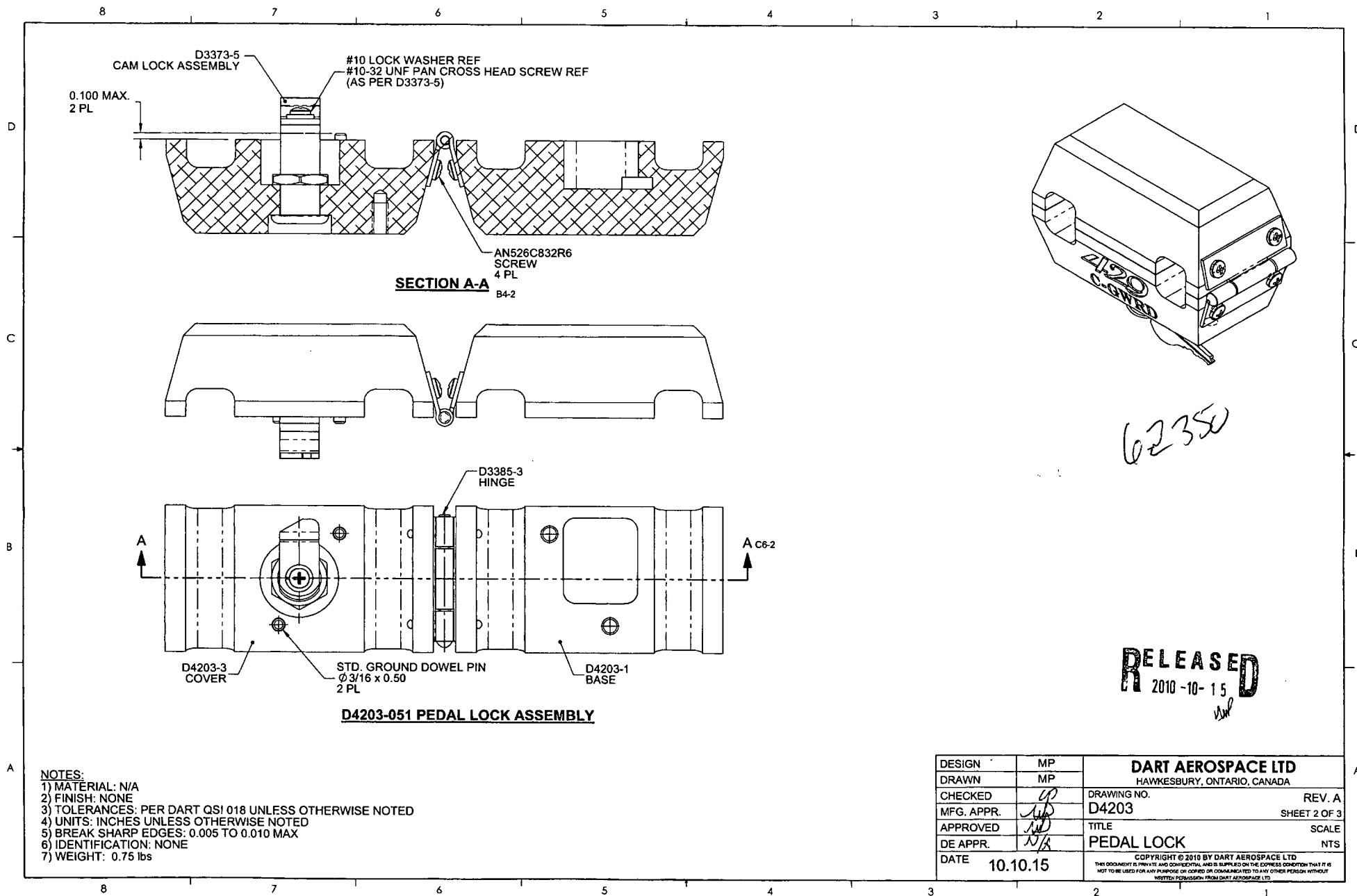
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



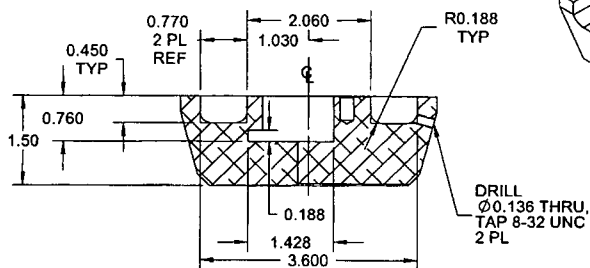
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

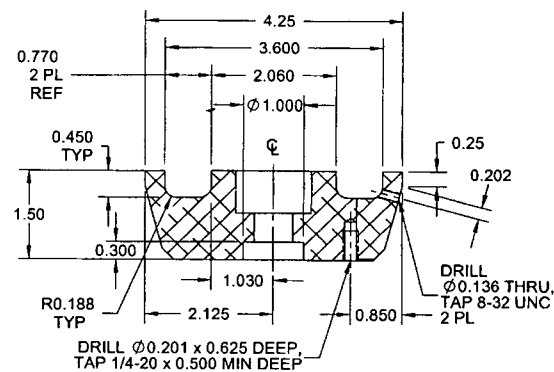
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

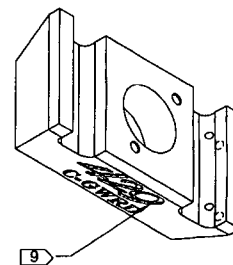
NOTE: Date & initial all entries



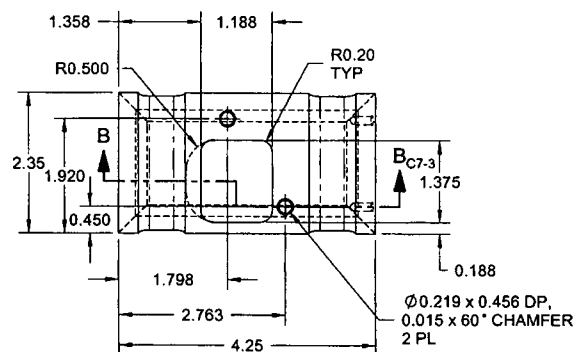
SECTION B-B
B6-3



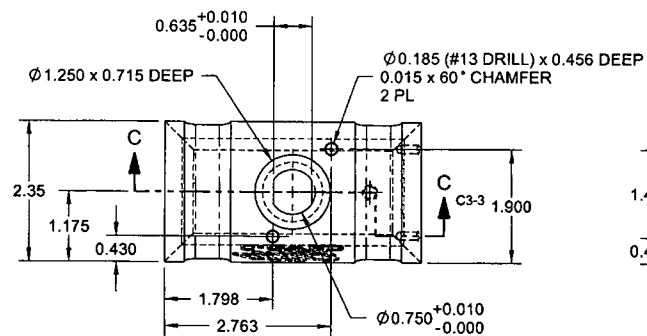
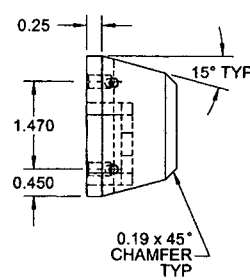
SECTION C-C
B2-3



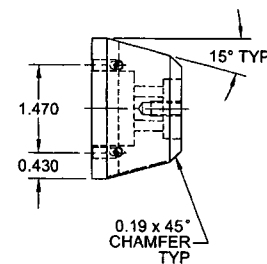
62350



D4203-1 BASE



D4203-3 COVER



- NOTES:**
- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) MASK INSIDE HOLES PRIOR TO FINISH
 - 9) ENGRAVE LOGO AND AIRCRAFT ID PER D4203-3.SLDPRT

RELEASED
2010-10-15

DESIGN	MP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MP		
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.	MP	D4203	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	PEDAL LOCK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries